FT. Rucker !

Work Order ID 73854

Friday, September 16, 2011 12:50:46 PM

Item ID: D2680-041 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Nut Plate

Start Date: 9/16/2011 **Start Qty:** 80.00 **Cust Item ID:**

Required Date: 10/14/2011 **Req'd Qty:** 80.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2680	Rev B1								
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2680 ☐Dwg Rev: B1 ☐Prog Rev: B1 ☐2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00							
Quality Control									

9/11-9-22

101

9/11-9-22

counted x101

8 w/o 173

GSPOIS

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 73854

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Revision ID:

Item Name: Nut Plate

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
Small Fab	**Memo**	0.00							
Small Fab	1- Deburr □2-C'sink as per Dwg D2680								
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
150 Powdercoat	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powder Coating	**Memo**	0.00							
	START TIME: 2:30 □OVEN TEMPERATURE: 400°F								
	□FINISH TIME: 3:00								

MU8439

11/09/26 101

counted 101

101 x 4 M-L 11/09/28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 73854

Friday, September 16, 2011 12:50:46 PM

Item ID: D2680-041 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Nut Plate

Start Date: 9/16/2011 **Start Qty:** 80.00 **Cust Item ID:**

Required Date: 10/14/2011 **Req'd Qty:** 80.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control									
170		0.00							
Small Fab	Small Fab								
Small Fab	**Memo** Install Nut Plate as per Dwg D2680	0.00							
180	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Work Order ID 73854

Friday, September 16, 2011 12:50:46 PM

Item ID: D2680-041 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Nut Plate

Start Date: 9/16/2011 **Start Qty:** 80.00 **Cust Item ID:**

Required Date: 10/14/2011 **Req'd Qty:** 80.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: 20	0.00				11/9/29		(101)	
Packaging	**Memo**	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00						11/10/3	
QC	**Memo**	0.00							
Quality Control								MF 11-09-2	

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 12:50:43 PM

Work Order ID: 73854

Parent Item: D2680-041

Parent Item Name: Nut Plate

Start Date: 9/16/2011 **Required Date:** 10/14/2011

Start Qty: 80.00 **Required Qty:** 80.00

Comments: IPP: D□04.10.01□Added Steps 2-4, 7-8□KJ/JLM
IPP Rev:E Now on WaterJet 06-10-12 JLM□
IPP rev F QC5 after c'sink 07.07.05 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA 1010/1025 sheet 16GA		Purchased	No			170	sf	63.7000	0.0131	1.103158			
				Location			**Loc Qty**		**Loc Code**				
				MAT019			63.7						
					116791		30.9						
					117500		32.8						
MS20426AD3-3 Rivet		Purchased	No			170	Each	1,749.000	2	160			
				Location			**Loc Qty**		**Loc Code**				
				ST316			1749						
					19099		1749						
MS21069L4 Nutplate		Purchased	No			110	Each	281.0000	1	80			
				Location			**Loc Qty**		**Loc Code**				
				ST302			281						
					106285		281						

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	73854
Description: Nut Plate	Part Number:	D2680-1
Inspection Dwg: D2680 **Rev:** B1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.104	+0.004/-0.001	.106	x		VFB02	
Ø0.266	+0.006/-0.001	.266	x		V	
Ø0.136	+0.005/-0.001	.138	x		V	
0.370	+/-0.010	.370	x		V	
0.280	+/-0.010	.286	x		V	
R0.688	+/-0.010	.688	x		RG	

Measured by:	IB	Audited by:		Prototype Approval:	N/A
Date:	11-9-07	Date:	11/09/07	Date:	N/A

Rev	Date	Change		Revised by	Approved
A	07.05.31	New Issue	P/O D2680-041	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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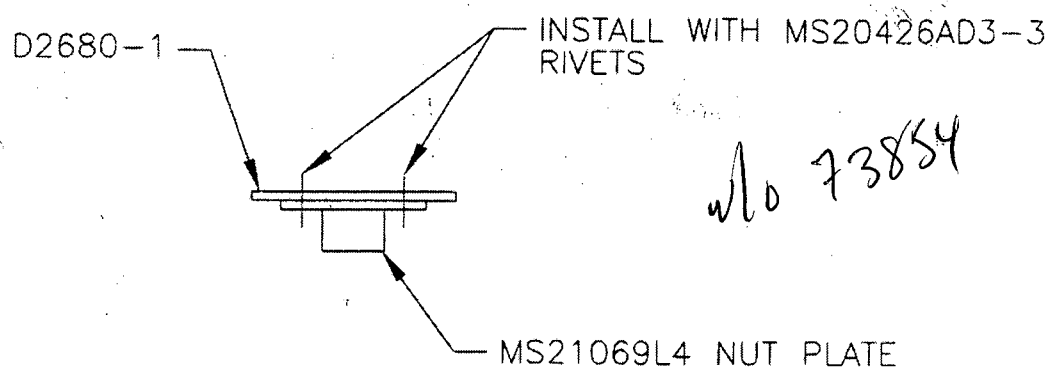
DART

COPY IS ISSUED

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED	APPROVED	DRAWING NO. D2680	REV. B SHEET 1 OF 1
DATE 98.12.14		TITLE NUT PLATE	SCALE 1:1

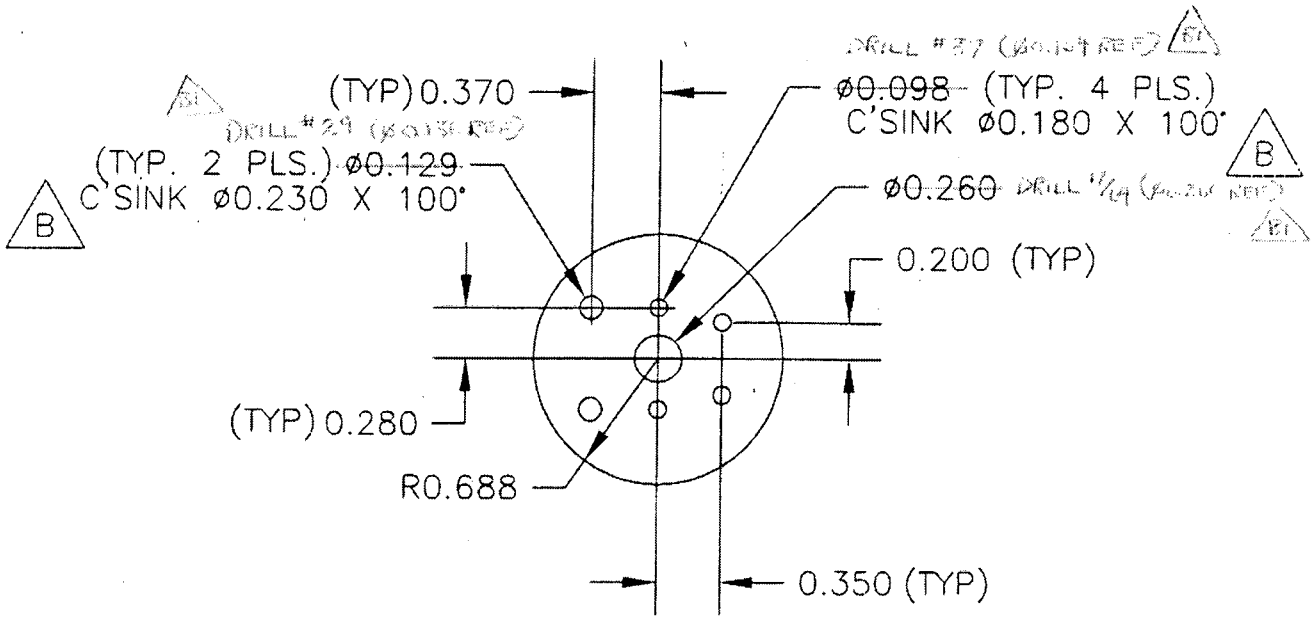
A	97.09.15	NEW ISSUE
B	98.12.14	CHANGE C'SINKS (PER TSR A1041)

RELEASED 98.12.14 DS



w/o 73854

D2680-041



MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.063 THICK (16 GAUGE)

CAD PLATE PRIOR TO INSTALLATION OF MS21069L4

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B1 RUBBER COAT WHITE (4.5 OZ) PER DART WI LOC 43

D2680-1

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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